



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200  
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20NR-09

Job Sheet 192512



DAS  
21  
9-30

Part No: 20NR-09

Job Qty: 5 pcs

Part Name: Side Plate - Solenoid



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/27/19

Job Tracking No:

Due Date: 3/26/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG 20NR-09 Rev. 5 IPP Rev. A 18.07.03 new issue DP Verify DD

Ship Via:

## Bill of Materials

## Job Routing

| Op<br>No | Operation           | Qty      | Start Date | Due<br>Date | Standard     |            | Workcenter/Supplier   |              | Sign-off    |
|----------|---------------------|----------|------------|-------------|--------------|------------|-----------------------|--------------|-------------|
|          |                     |          |            |             | Setup<br>Hrs | Run<br>Hrs | Workcenter / Supplier | Lead<br>Time |             |
| 100      | Waterjet - Omax - 1 | 5<br>pcs |            | 3/26/19     | 0.00         | 1.00       | Waterjet - Omax       |              | DL 19/04/03 |
| 110      | QC 2                | 5<br>pcs |            | 3/26/19     | 0.00         | 0.00       | QC 2 - 1              |              |             |
|          |                     |          |            |             |              |            | QC 2 - 12             |              |             |
|          |                     |          |            |             |              |            | QC 2 - 14             |              |             |
|          |                     |          |            |             |              |            | QC 2 - 17             |              |             |
|          |                     |          |            |             |              |            | QC 2 - 19             |              |             |
|          |                     |          |            |             |              |            | QC 2 - 2              |              |             |
|          |                     |          |            |             |              |            | QC 2 - 20             |              |             |
|          |                     |          |            |             |              |            | QC 2 - 22             |              |             |
|          |                     |          |            |             |              |            | QC 2 - 23             |              |             |
|          |                     |          |            |             |              |            | QC 2 - 25             |              |             |
|          |                     |          |            |             |              |            | QC 2 - 32             |              |             |
|          |                     |          |            |             |              |            | QC 2 - 33             |              |             |
|          |                     |          |            |             |              |            | QC 2 - 35             |              |             |
|          |                     |          |            |             |              |            | QC 2 - 39             |              |             |
|          |                     |          |            |             |              |            | QC 2 - 4              |              |             |
|          |                     |          |            |             |              |            | QC 2 - 40             |              |             |
|          |                     |          |            |             |              |            | QC 2 - 44             |              |             |
|          |                     |          |            |             |              |            | QC 2 - 45             |              |             |
|          |                     |          |            |             |              |            | QC 2 - 48             |              | DL 19/04/03 |
|          |                     |          |            |             |              |            | QC 2 - 49             |              |             |
|          |                     |          |            |             |              |            | QC 2 - 50             |              |             |
|          |                     |          |            |             |              |            | QC 2 - 51             |              |             |
|          |                     |          |            |             |              |            | QC 2 - 52             |              |             |
|          |                     |          |            |             |              |            | QC 2 - 56             |              |             |
|          |                     |          |            |             |              |            | QC 2 - 57             |              |             |
|          |                     |          |            |             |              |            | QC 2 - 62             |              |             |
|          |                     |          |            |             |              |            | QC 2 - 63             |              |             |
|          |                     |          |            |             |              |            | QC 2 - 8              |              |             |
|          |                     |          |            |             |              |            | QC 2 - 66             |              |             |



Dart Aerospace Ltd.  
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CANADA  
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Email: sales@dartaero.com  
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Container No: S169143



Part: 20NR-09

Job No: 192512

Serial No/Batch: S169143

Revision: 5

Inspector:

Exp Date:

Instructions:

Date: 06/09/19

Plex 3/27/19 8:34 AM Dart.lajeunesse.marie

|                                 |       |         |           |                             |                    |
|---------------------------------|-------|---------|-----------|-----------------------------|--------------------|
|                                 |       |         |           | QC 2 - 64                   |                    |
|                                 |       |         |           | QC 2 - 65                   |                    |
|                                 |       |         |           | QC 2 - 5                    |                    |
| 115 Conventional Mill - 1 - B4B | 5 pcs | 3/26/19 | 0.00 1.67 | Conventional Mill - 1 - B4B |                    |
|                                 |       |         |           | Conventional Mill - 2 - B4B |                    |
| 116 QC 2                        | 5 pcs | 3/26/19 | 0.00 0.00 | QC 2 - 1                    |                    |
|                                 |       |         |           | QC 2 - 12                   |                    |
|                                 |       |         |           | QC 2 - 14                   |                    |
|                                 |       |         |           | QC 2 - 17                   |                    |
|                                 |       |         |           | QC 2 - 19                   |                    |
|                                 |       |         |           | QC 2 - 2                    |                    |
|                                 |       |         |           | QC 2 - 20                   |                    |
|                                 |       |         |           | QC 2 - 22                   |                    |
|                                 |       |         |           | QC 2 - 23                   |                    |
|                                 |       |         |           | QC 2 - 25                   |                    |
|                                 |       |         |           | QC 2 - 32                   |                    |
|                                 |       |         |           | QC 2 - 33                   |                    |
|                                 |       |         |           | QC 2 - 35                   |                    |
|                                 |       |         |           | QC 2 - 39                   |                    |
|                                 |       |         |           | QC 2 - 4                    |                    |
|                                 |       |         |           | QC 2 - 40                   |                    |
|                                 |       |         |           | QC 2 - 44                   |                    |
|                                 |       |         |           | QC 2 - 45                   |                    |
|                                 |       |         |           | QC 2 - 48                   |                    |
|                                 |       |         |           | QC 2 - 49                   |                    |
|                                 |       |         |           | QC 2 - 50                   |                    |
|                                 |       |         |           | QC 2 - 51                   |                    |
|                                 |       |         |           | QC 2 - 52                   |                    |
|                                 |       |         |           | QC 2 - 56                   |                    |
|                                 |       |         |           | QC 2 - 57                   |                    |
|                                 |       |         |           | QC 2 - 62                   |                    |
|                                 |       |         |           | QC 2 - 63                   |                    |
|                                 |       |         |           | QC 2 - 8                    |                    |
|                                 |       |         |           | QC 2 - 66                   |                    |
|                                 |       |         |           | QC 2 - 64                   |                    |
|                                 |       |         |           | QC 2 - 65                   |                    |
|                                 |       |         |           | QC 2 - 5                    |                    |
| 120 NV5000 - 1 - B4B            | 5 pcs | 3/26/19 | 0.00 5.00 | NV5000 - 1 - B4B            | PJ 17-04-14 J.C.L. |
|                                 |       |         |           | NV5000 - 2 - B4B            |                    |
| 130 QC 2                        | 5 pcs | 3/26/19 | 0.00 0.00 | QC 2 - 1                    | PJ 17-04-14        |
|                                 |       |         |           | QC 2 - 12                   |                    |
|                                 |       |         |           | QC 2 - 14                   |                    |
|                                 |       |         |           | QC 2 - 17                   |                    |
|                                 |       |         |           | QC 2 - 19                   |                    |
|                                 |       |         |           | QC 2 - 2                    |                    |
|                                 |       |         |           | QC 2 - 20                   |                    |
|                                 |       |         |           | QC 2 - 22                   |                    |
|                                 |       |         |           | QC 2 - 23                   |                    |
|                                 |       |         |           | QC 2 - 25                   |                    |
|                                 |       |         |           | QC 2 - 32                   | J.C.L. 19-04-17    |
|                                 |       |         |           | QC 2 - 33                   |                    |
|                                 |       |         |           | QC 2 - 35                   |                    |
|                                 |       |         |           | QC 2 - 39                   |                    |
|                                 |       |         |           | QC 2 - 4                    |                    |
|                                 |       |         |           | QC 2 - 40                   |                    |
|                                 |       |         |           | QC 2 - 44                   |                    |
|                                 |       |         |           | QC 2 - 45                   |                    |

|                                   |          |         |           |              |                        |               |
|-----------------------------------|----------|---------|-----------|--------------|------------------------|---------------|
|                                   |          |         |           |              | QC 2 - 48              |               |
|                                   |          |         |           |              | QC 2 - 49              |               |
|                                   |          |         |           |              | QC 2 - 50              |               |
|                                   |          |         |           |              | QC 2 - 51              |               |
|                                   |          |         |           |              | QC 2 - 52              |               |
|                                   |          |         |           |              | QC 2 - 56              |               |
|                                   |          |         |           |              | QC 2 - 57              |               |
|                                   |          |         |           |              | QC 2 - 62              |               |
|                                   |          |         |           |              | QC 2 - 63              |               |
|                                   |          |         |           |              | QC 2 - 8               |               |
|                                   |          |         |           |              | QC 2 - 66              |               |
|                                   |          |         |           |              | QC 2 - 64              |               |
|                                   |          |         |           |              | QC 2 - 65              |               |
|                                   |          |         |           |              | QC 2 - 5               |               |
| 140 QC 8                          | 5<br>pcs | 3/26/19 | 0.00 0.00 |              | QC 8 - 12              |               |
|                                   |          |         |           |              | QC 8 - 14              | 9/19/05/03    |
|                                   |          |         |           |              | QC 8 - 17              |               |
|                                   |          |         |           |              | QC 8 - 20              |               |
|                                   |          |         |           |              | QC 8 - 25              |               |
|                                   |          |         |           |              | QC 8 - 3               |               |
|                                   |          |         |           |              | QC 8 - 32              |               |
|                                   |          |         |           |              | QC 8 - 33              |               |
|                                   |          |         |           |              | QC 8 - 35              |               |
|                                   |          |         |           |              | QC 8 - 39              |               |
|                                   |          |         |           |              | QC 8 - 4               |               |
|                                   |          |         |           |              | QC 8 - 44              |               |
|                                   |          |         |           |              | QC 8 - 45              |               |
|                                   |          |         |           |              | QC 8 - 49              |               |
|                                   |          |         |           |              | QC 8 - 58              |               |
|                                   |          |         |           |              | QC 8 - 8               |               |
|                                   |          |         |           |              | QC 8 - 9               |               |
|                                   |          |         |           |              | QC 8 - 68              |               |
|                                   |          |         |           |              | QC 8 - 67              |               |
|                                   |          |         |           |              | QC 8 - 1 (A)           |               |
|                                   |          |         |           |              | QC 8 - 47              |               |
|                                   |          |         |           |              | QC 8 - 40              |               |
|                                   |          |         |           |              | QC 8 - 52              |               |
|                                   |          |         |           |              | QC 8 - 23              |               |
| 170 Outsource - 13 - Zinc Plating | 5<br>pcs | 3/26/19 | 0.00 0.00 | Group Altech |                        | 2019-05-03 KH |
| 180 Packaging 2-1 - Receive - B4B | 5<br>pcs | 3/26/19 | 0.00 0.00 |              | Packaging 2 - 1 - B4B  |               |
|                                   |          |         |           |              | Packaging 2 - 2 - B4B  |               |
|                                   |          |         |           |              | Packaging 2 - 3 - B4B  |               |
|                                   |          |         |           |              | Packaging 2 - 5 - B4B  |               |
|                                   |          |         |           |              | Packaging 2 - 4 - B4B  |               |
|                                   |          |         |           |              | Packaging 2 - 6 - B4B  |               |
|                                   |          |         |           |              | Packaging 2 - 7 - B4B  |               |
|                                   |          |         |           |              | Packaging 2 - 8 - B4B  |               |
|                                   |          |         |           |              | Packaging 2 - 9 - B4B  |               |
|                                   |          |         |           |              | Packaging 2 - 10 - B4B |               |
|                                   |          |         |           |              | Packaging 2 - 11 - B4B |               |
|                                   |          |         |           |              | Packaging 2 - 12 - B4B |               |
|                                   |          |         |           |              | Packaging 2 - 13 - B4B |               |
|                                   |          |         |           |              | Packaging 2 - 14 - B4B |               |
|                                   |          |         |           |              | Packaging 2 - 15 - B4B |               |
|                                   |          |         |           |              | Packaging 2 - 16 - B4B |               |
|                                   |          |         |           |              | Packaging 2 - 17 - B4B |               |
|                                   |          |         |           |              | Packaging 2 - 18 - B4B |               |
|                                   |          |         |           |              | Packaging 2 - 19 - B4B |               |

|                                 |          |         |           |                        |                        |                   |
|---------------------------------|----------|---------|-----------|------------------------|------------------------|-------------------|
|                                 |          |         |           |                        | Packaging 2 - 20 - B4B |                   |
|                                 |          |         |           |                        | Packaging 2 - 21 - B4B |                   |
|                                 |          |         |           |                        | Packaging 2 - 22 - B4B |                   |
|                                 |          |         |           |                        | Packaging 2 - 23 - B4B |                   |
|                                 |          |         |           |                        | Packaging 2 - 24 - B4B |                   |
|                                 |          |         |           |                        | Packaging 2 - 25 - B4B |                   |
|                                 |          |         |           |                        | Packaging 2 - 26 - B4B |                   |
|                                 |          |         |           |                        | Packaging 2 - 27 - B4B |                   |
|                                 |          |         |           |                        | Packaging 2 - 28 - B4B |                   |
|                                 |          |         |           |                        | Packaging 2 - 29 - B4B |                   |
|                                 |          |         |           |                        | Packaging 2 - 30 - B4B |                   |
|                                 |          |         |           |                        | Packaging 2 - 31 - B4B |                   |
|                                 |          |         |           |                        | Packaging 2 - 32 - B4B |                   |
|                                 |          |         |           |                        | Packaging 2 - 33 - B4B |                   |
|                                 |          |         |           |                        | Packaging 2 - 34 - B4B |                   |
|                                 |          |         |           |                        | Packaging 2 - 35 - B4B |                   |
|                                 |          |         |           |                        | Packaging 2 - 36 - B4B |                   |
| 190 QC 6                        | 5<br>pcs | 3/26/19 | 0.00 0.00 | QC 6 - 9               | MAY 13 2019            | DAS<br>40<br>9-89 |
|                                 |          |         |           | QC 6 - 68              |                        |                   |
|                                 |          |         |           | QC 6 - 61              |                        |                   |
| 200 Packaging 3-1 - Stock - B4B | 5<br>pcs | 3/26/19 | 0.00 0.00 | Packaging 3 - 1 - B4B  |                        |                   |
|                                 |          |         |           | Packaging 3 - 2 - B4B  |                        |                   |
|                                 |          |         |           | Packaging 3 - 3 - B4B  |                        |                   |
|                                 |          |         |           | Packaging 3 - 4 - B4B  |                        |                   |
|                                 |          |         |           | Packaging 3 - 5 - B4B  |                        |                   |
|                                 |          |         |           | Packaging 3 - 6 - B4B  |                        |                   |
|                                 |          |         |           | Packaging 3 - 7 - B4B  |                        |                   |
|                                 |          |         |           | Packaging 3 - 8 - B4B  |                        |                   |
|                                 |          |         |           | Packaging 3 - 9 - B4B  |                        |                   |
|                                 |          |         |           | Packaging 3 - 10 - B4B |                        |                   |
|                                 |          |         |           | Packaging 3 - 11 - B4B |                        |                   |
|                                 |          |         |           | Packaging 3 - 12 - B4B |                        |                   |
|                                 |          |         |           | Packaging 3 - 13 - B4B |                        |                   |
|                                 |          |         |           | Packaging 3 - 14 - B4B |                        |                   |
|                                 |          |         |           | Packaging 3 - 15 - B4B |                        |                   |
|                                 |          |         |           | Packaging 3 - 16 - B4B |                        |                   |
|                                 |          |         |           | Packaging 3 - 17 - B4B |                        |                   |
|                                 |          |         |           | Packaging 3 - 18 - B4B |                        |                   |
|                                 |          |         |           | Packaging 3 - 19 - B4B |                        |                   |
|                                 |          |         |           | Packaging 3 - 20 - B4B |                        |                   |
|                                 |          |         |           | Packaging 3 - 21 - B4B |                        |                   |
|                                 |          |         |           | Packaging 3 - 22 - B4B |                        |                   |
|                                 |          |         |           | Packaging 3 - 23 - B4B |                        |                   |
|                                 |          |         |           | Packaging 3 - 24 - B4B |                        |                   |
|                                 |          |         |           | Packaging 3 - 25 - B4B |                        |                   |
|                                 |          |         |           | Packaging 3 - 26 - B4B |                        |                   |
|                                 |          |         |           | Packaging 3 - 27 - B4B |                        |                   |
|                                 |          |         |           | Packaging 3 - 28 - B4B |                        |                   |
|                                 |          |         |           | Packaging 3 - 29 - B4B |                        |                   |
|                                 |          |         |           | Packaging 3 - 30 - B4B |                        |                   |
|                                 |          |         |           | Packaging 3 - 31 - B4B |                        |                   |
|                                 |          |         |           | Packaging 3 - 32 - B4B |                        |                   |
|                                 |          |         |           | Packaging 3 - 33 - B4B |                        |                   |
|                                 |          |         |           | Packaging 3 - 34 - B4B |                        |                   |
|                                 |          |         |           | Packaging 3 - 35 - B4B |                        |                   |
|                                 |          |         |           | Packaging 3 - 36 - B4B |                        |                   |
| 210 QC 21 - SA                  | 5<br>pcs | 3/26/19 | 0.00 0.00 | QC 21 - SA - 21        |                        |                   |
|                                 |          |         |           | QC 21 - SA - 70        |                        |                   |
|                                 |          |         |           | QC 21 - SA - 53        |                        |                   |
|                                 |          |         |           |                        |                        | DAS<br>21<br>9-89 |
|                                 |          |         |           |                        | MAY 15 2019            |                   |

Part Op 100 - 1-Cut as per DWG. DWG. Rev: \_\_\_\_\_ PROG. Rev: \_\_\_\_\_ 2-Debur if necessary

Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB)

115 - 1-Machine as per DWG. Face as per drawing 2-Debur

120 - 1-Machine as per folio FC716 FOLIO REV: AA DWG REV: 5 2-Debur

130 - (QC2- Inspect parts off machine FAI/FAIB)

140 - (QC8- Inspect parts - second check)

170 - Issue P/O; \_\_\_\_\_ -Zinc plate, ASTM B633 TYPE 2 SC2 -Color; yellow -Material type; 4140 -Certificate of Conformity is required

180 - (Receive & Inspect for Damage & Mat'l Certs)

190 - QC6- All purchased or subcontracted products)

200 - Identify as per dwg & Stock Location: \_\_\_\_\_)

210 - (QC21- Final Inspection - Work Order Release)

### Job BOM

| Part / Item     | Component Name        | Quantity            | Operation               | Container       |
|-----------------|-----------------------|---------------------|-------------------------|-----------------|
| MT-4140-S-0.500 | AISI 4140 Steel Sheet | 5.5500 sf (1.11 ea) | 100-Waterjet - Omax - 1 | <u>5165 699</u> |

### Job Allocations

| Operation               | Component Part  | Required | Inventory | Allocated |
|-------------------------|-----------------|----------|-----------|-----------|
| 100-Waterjet - Omax - 1 | MT-4140-S-0.500 | 6        | 48        | 0         |

### Part Specifications

Specifications could not be found.

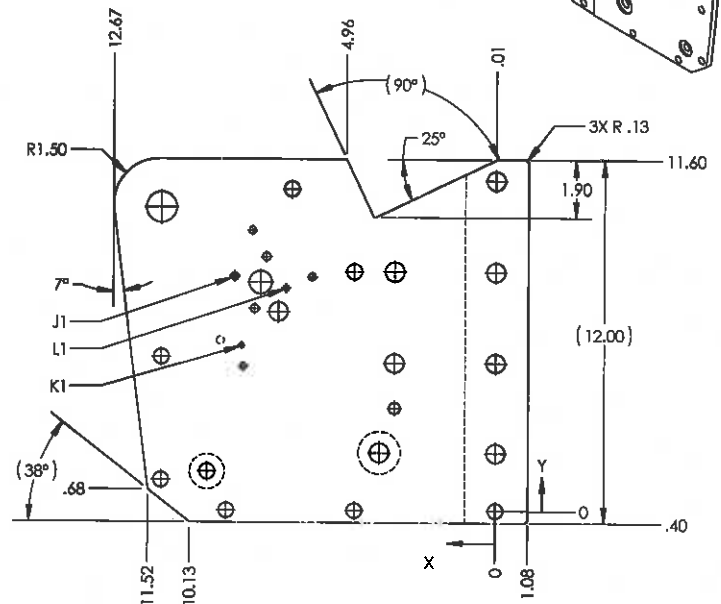
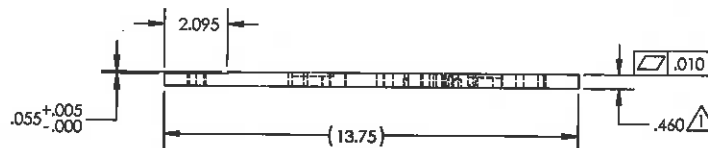
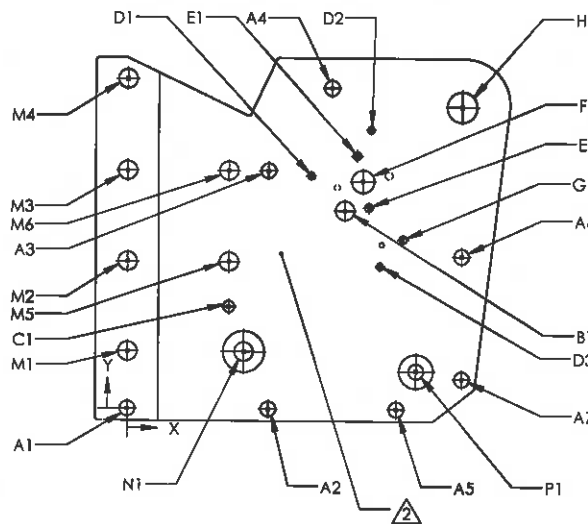
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WORK ORDER  
NO. ~~192572~~ M-5  
192572 190212

| REV | ECR     | DESCRIPTION                                                                                                     | DATE      | INITIAL | APPROVED |
|-----|---------|-----------------------------------------------------------------------------------------------------------------|-----------|---------|----------|
| 3   |         | AS DRAWN BY CANAM                                                                                               | 7/22/2013 | CPS     |          |
| 4   |         | CHD LOCATION OF HOLE D3 TO MATCH SOLENOID COVER.                                                                | 10/9/2013 | CR      | JG       |
| 5   | 14-0101 | CHD TITLE BLOCK WAS RED BARN IS DART. ADDED MACHINE ENGRAVE NOTE, ADDED A GEOMETRIC FLATNESS TOLERANCE OF .010. | 7/30/2014 | Tp      | RW       |

| TAG | X LOC  | Y LOC  | SIZE |
|-----|--------|--------|------|
| A1  | .000   | .000   |      |
| A2  | 4.675  | .000   |      |
| A3  | 4.675  | 7.900  |      |
| A4  | 6.771  | 10.617 |      |
| A5  | 8.925  | .000   |      |
| A6  | 11.081 | 5.101  |      |
| A7  | 11.088 | 1.002  |      |
| B1  | 7.210  | 6.600  |      |
| C1  | 3.355  | 3.400  |      |
| D1  | 6.090  | 7.735  |      |
| D2  | 8.075  | 9.255  |      |
| D3  | 8.370  | 4.758  |      |
| E1  | 7.609  | 8.407  |      |
| F1  | 8.003  | 6.700  |      |
| G1  | 9.135  | 5.643  |      |
| H1  | 11.087 | 10.012 |      |
| J1  | 8.659  | 7.751  |      |
| K1  | 8.425  | 5.475  |      |
| L1  | 6.952  | 7.357  |      |
| M1  | .000   | 1.900  |      |
| M2  | .000   | 4.900  |      |
| M3  | .000   | 7.900  |      |
| M4  | .000   | 10.900 |      |
| M5  | 3.355  | 4.900  |      |
| M6  | 3.355  | 7.900  |      |
| N1  | 3.855  | 1.900  |      |
| P1  | 9.575  | 1.256  |      |



#### NOTES:

- STRESS RELIEF AND GROUND.
- MACHINE ENGRAVE BATCH NUMBER.

|                                                        |                                                                        |
|--------------------------------------------------------|------------------------------------------------------------------------|
| <b>DART</b><br>AEROSPACE                               |                                                                        |
| TITLE<br><b>SIDE PLATE - SOLENOID</b>                  |                                                                        |
| DWG NO.<br><b>20NR-09</b>                              | REV<br><b>5</b>                                                        |
| MATL. 4140                                             | DRAWN BY: CANAM                                                        |
| UNLESS OTHERWISE SPECIFIED<br>DIMENSIONS ARE IN INCHES | APPROVED: <i>[Signature]</i>                                           |
| XXX ±.005<br>XX ±.01<br>X ±.1                          | FRACTIONS ± 1/32<br>ANGLES ± 5°<br>DECIMALS ± .001                     |
| 1. BREAK ALL SHARP EDGES .015 ± .001<br>OR .015        | CAD PLATE YELLOW<br>SPEC QQ-P-416F, TYPE II, CLASS II<br>USED ON MODEL |
| 2. DIMENSIONAL LIMITS APPLY AFTER<br>PLATING           |                                                                        |
| SCALE<br><b>1:4</b>                                    | DATE<br><b>12/11/1995</b>                                              |
| SHEET 1 OF 1                                           |                                                                        |

| ASSY QTY | ASSY QTY | B/O | Part #  | UNIT QTY | Description           | Material | B/O INFORMATION OR SPECIFICATIONS |
|----------|----------|-----|---------|----------|-----------------------|----------|-----------------------------------|
|          |          |     | 20NR-09 | 1        | SIDE PLATE - SOLENOID | 4140     | 1/2 X 12-1/8 X 13-7/8             |

192572

|                                                |                      |                                      |
|------------------------------------------------|----------------------|--------------------------------------|
| <b>DART AEROSPACE LTD</b>                      |                      | <b>Work Order:</b> <del>192572</del> |
| <b>Description:</b> <i>side plate selenoid</i> |                      | <b>Part Number:</b> <i>20A2-07</i>   |
| <b>Inspection Dwg:</b>                         | <b>Rev:</b> <i>5</i> | <b>Page 1 of 1</b>                   |

### INSPECTION SHEET

| Drawing Dimension                                                                 | Tolerance             | Actual Dimension     | Accept | Reject | Method of Inspection         | Comments                |
|-----------------------------------------------------------------------------------|-----------------------|----------------------|--------|--------|------------------------------|-------------------------|
|  | <i>.010</i>           | <i>.004</i>          | ✓      |        | <i>mandrel / height gage</i> |                         |
| <i>.055</i>                                                                       | <i>-.000 / +.005</i>  | <i>.0575</i>         | ✓      |        | <i>dial indicator</i>        |                         |
| <i>.460</i>                                                                       | <i>H-.005</i>         | <i>.455 / .459</i>   | ✓      |        | <i>PSOI</i>                  |                         |
| <i>2.095</i>                                                                      | <i>H-.005</i>         | <i>2.096 / 2.095</i> | ✓      |        | <i>PSOI</i>                  | <i>WT edge</i>          |
| <i>2.500</i>                                                                      | <i>-.001 / +.006</i>  | <i>.499</i>          | ✓      |        | <i>pin</i>                   |                         |
| <i>2.625</i>                                                                      | <i>-.001 / +.008</i>  | <i>.629</i>          | ✓      |        | <i>pin</i>                   |                         |
| <i>2.375</i>                                                                      | <i>-.001 / +.006</i>  | <i>.376</i>          | ✓      |        | <i>pin</i>                   |                         |
| <i>2.750</i>                                                                      | <i>-.001 / +.008</i>  | <i>.751</i>          | ✓      |        | <i>pin</i>                   |                         |
| <i>2.251</i>                                                                      | <i>-.001 / +.005</i>  | <i>.253</i>          | ✓      |        | <i>pin</i>                   |                         |
| <i>1.38</i>                                                                       | <i>H-.010</i>         | <i>.390</i>          | ✓      |        | <i>PSOI</i>                  |                         |
| <i>1/4-28</i>                                                                     | <i>90 / no 90</i>     | <i>90</i>            | ✓      |        | <i>90 / no 90</i>            |                         |
| <i>8-32</i>                                                                       | <i>90 / no 90</i>     | <i>90</i>            | ✓      |        | <i>90 / no 90</i>            |                         |
| <i>1.00</i>                                                                       | <i>-.001 / +.010</i>  | <i>1.001</i>         | ✓      |        | <i>pin</i>                   |                         |
| <i>1.130</i>                                                                      | <i>-.001 / +.005</i>  | <i>1.133</i>         | ✓      |        | <i>pin</i>                   |                         |
| <i>1.125</i>                                                                      | <i>-.001 / +.005</i>  | <i>1.1255</i>        | ✓      |        | <i>dial indicator</i>        |                         |
| <i>1.380</i>                                                                      | <i>-.000 / +.005</i>  | <i>1.383</i>         | ✓      |        | <i>pin</i>                   |                         |
| <i>1.125</i>                                                                      | <i>-.001 / +.000</i>  | <i>.1255</i>         | ✓      |        | <i>dial indicator</i>        |                         |
| <i>2.6253</i>                                                                     | <i>-.001 / +.0004</i> | <i>.6262</i>         | ✓      |        | <i>gage / PSOI</i>           | <i>.003 / R plating</i> |
| <i>2.266</i>                                                                      | <i>-.001 / +.005</i>  | <i>.265</i>          | ✓      |        | <i>pin</i>                   |                         |
| <i>2.250</i>                                                                      | <i>-.001 / +.000</i>  | <i>.2490</i>         | ✓      |        | <i>pin</i>                   |                         |
| <i>2.187</i>                                                                      | <i>-.001 / +.000</i>  | <i>.186</i>          | ✓      |        | <i>pin</i>                   |                         |
| <i>(A) (7.20)</i>                                                                 | <i>H-.005</i>         | <i>7.20</i>          | ✓      |        | <i>dial indicator</i>        |                         |
| <i>(B) 1.500</i>                                                                  | <i>H-.005</i>         | <i>1.600</i>         | ✓      |        | <i>dial indicator</i>        |                         |
| <i>.400</i>                                                                       | <i>H-.010</i>         | <i>.390</i>          | ✓      |        | <i>PSOI</i>                  | <i>WT edge</i>          |
|                                                                                   |                       |                      |        |        |                              |                         |
|                                                                                   |                       |                      |        |        |                              |                         |
|                                                                                   |                       |                      |        |        |                              |                         |
|                                                                                   |                       |                      |        |        |                              |                         |
|                                                                                   |                       |                      |        |        |                              |                         |
|                                                                                   |                       |                      |        |        |                              |                         |

|                                      |                                |                      |
|--------------------------------------|--------------------------------|----------------------|
| <b>Measured by:</b> <i>PS/S.C.-L</i> | <b>Checked by:</b> <i>Orly</i> | <b>QC Inspector:</b> |
| <b>Date:</b> <i>12-01-14</i>         | <b>Date:</b> <i>19/05/03</i>   | <b>Date:</b>         |

|                                                |              |
|------------------------------------------------|--------------|
| <b>Engineering Approval:</b><br>(if necessary) | <b>Date:</b> |
|------------------------------------------------|--------------|

| Rev | Date     | Change    | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| A   | 14.07.31 | New Issue | KJ         |          |



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200

# PURCHASE ORDER

## POHB043374



**Supplier:** GRO002-VC  
Group Altech  
2455 Halpern  
St Laurent  
QC  
H4S 1N9 Canada  
Phone: 514-335-3666  
Fax: 514-335-3868

**Attention:** Grenon, Sylvie

**Ship To:** 1270 Aberdeen Street  
Hawkesbury  
ON  
K6A 1K7 Canada  
Phone: 613-632-5200

**PO No:** POHB043374

**PO Date:** 5/3/19

**Due Date:** 5/10/19

**Purchase Order**

**Revision:**

**Revision Date:**

**Ship-To Contact:** Phone:

**Via:** Ground

**Pynt Terms:** Net 60

**Freight Terms:**

**Special Comments:**

### Items

| Line Item           | Job    | Part    | Description                                                                                                                                                      | Status | Account | Due Date    | Order Quantity | Received Quantity | Balance | Unit Price (CAD) | Extended Price  |
|---------------------|--------|---------|------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------|---------|-------------|----------------|-------------------|---------|------------------|-----------------|
| 1                   | 192513 | 20NR-43 | Side Plate - Cover<br>-Issue P/O;<br>-Zinc plate, ASTM B633<br>TYPE 2 SC2<br>-Color; yellow<br>-Material type; 4140<br>-Certificate of Conformity is required    | Firmed | -       | 5/10/19     | 5 pcs          | 0 pcs             | 5 pcs   | \$27.00/pcs      | \$135.00        |
|                     |        |         |                                                                                                                                                                  | 5 X    |         | MAY 09 2019 |                |                   |         |                  |                 |
| 2                   | 192512 | 20NR-09 | Side Plate - Solenoid<br>-Issue P/O;<br>-Zinc plate, ASTM B633<br>TYPE 2 SC2<br>-Color; yellow<br>-Material type; 4140<br>-Certificate of Conformity is required | Firmed | -       | 5/10/19     | 6 pcs          | 0 pcs             | 6 pcs   | \$27.00/pcs      | \$162.00        |
|                     |        |         |                                                                                                                                                                  | 6 X    |         | MAY 09 2019 |                |                   |         |                  |                 |
| <b>Grand Total:</b> |        |         |                                                                                                                                                                  |        |         |             |                |                   |         |                  | <b>\$297.00</b> |

DAS  
40  
9-89





Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200

# PURCHASE ORDER

## POHB043374



### Order Notes

#### Procurement Quality Clauses

A005 right of entry  
A012 chemical and physical test report  
A016 personnel qualification  
A017 raw material identification (as applicable)

A022 Apical Processing  
A024 process certifications  
A026 certification of material conformance

A041 quality management system  
A042 dart notification by supplier  
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit [www.dartaerospace.com](http://www.dartaerospace.com) for further explanation.

Plex 5/6/19 10:18 AM Dart.Guerin.Kimberley

**Certificat de Conformité / Certificate of Compliance**  
(018964-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9  
Tel: 514-335-3666 Fax: 514-335-3868  
www.groupealtech.com

**Bon de Livraison / Packing Slip****018964- 1****Livré à / Ship to**

**DART AEROSPACE LTD**  
1270 ABERDEEN STREET  
HAWKESBURY, ON, K6A1K7  
CANADA  
Tel.: 613-632-5200 Fax.:

**Client / Customer:**

**DART AEROSPACE LTD**  
1270 ABERDEEN STREET  
HAWKESBURY, ON, K6A1K7  
CANADA  
BUYER:

| Date expédition<br>Ship date | Créé Par<br>Generated By                                  | Transport / No de Compte<br>Courier / Acc. No                                                     | Bon de commande Client<br>Customer Purchase Order No |                   |                 |                   |               |                        |
|------------------------------|-----------------------------------------------------------|---------------------------------------------------------------------------------------------------|------------------------------------------------------|-------------------|-----------------|-------------------|---------------|------------------------|
| 07-May-2019                  | Jessie Boisvert                                           |                                                                                                   | POHB043374                                           |                   |                 |                   |               |                        |
| #Ligne<br>Line#              | No. de Série / # Pièce<br>Part Number / Line Item Details | Description pièce(s)                                                                              | CATG.<br>U/M                                         | Comm.<br>/Ordered | Exp/<br>Shipped | Qté NC/<br>NC Qty | Qté<br>Scrap/ | À venir/<br>Back Order |
| 1                            | 20NR-43<br>Rev.                                           | 20NR-43<br>01 -ZINC-YELLOW [ZINC YELLOW]<br>OLD YELLOW CHROMATE, 96 hours<br>ASTM B633 TYPE2 SC2  | ZINC<br>CH                                           | 5                 | 5               | 0                 | 0             | 0                      |
| 2                            | 20NR-09<br>Rev.                                           | 20NR-09<br>01 -ZINC-YELLOW [ZINC YELLOW]<br>OLD YELLOW CHROMATE, 96 hours<br>ASTM B633 TYPE 2 SC2 | ZINC<br>CH                                           | 6                 | 6               | 0                 | 0             | 0                      |

**RECEIVED**  
**MAY 08 2019**  
**DART AEROSPACE LTD.**

**DAS**  
**40**  
**9-89**

**Notes Additionnelles / Additional Notes****Epaisseur réelle  
Actual Thickness****Inspecteur Qualité  
Quality Inspector****Réçu par  
Received By**

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.  
Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.  
Our financial and legal responsibility will not be higher than the amount of invoice.

Entered: 2/2 Date: Oct 25/19



NCR No. 19-7567

## WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

|                                                                                                                                                                                                                                                                                                                                                                                                |  |                                                                                                                                          |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |  |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |                         |  |                           |  |  |  |                                                                                           |  |
|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|------------------------------------------------------------------------------------------------------------------------------------------|--|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|--|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------|--|---------------------------|--|--|--|-------------------------------------------------------------------------------------------|--|
| Job: <u>192562</u>                                                                                                                                                                                                                                                                                                                                                                             |  | <b>DISPOSITION</b><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input checked="" type="checkbox"/> |  | <b>DEPARTMENT/PROCESS</b><br>Skid-tube <input type="checkbox"/> Cross tube <input type="checkbox"/> Eng. (Non-AW) <input type="checkbox"/> Engineering <input type="checkbox"/><br>Machining <input checked="" type="checkbox"/> Small Fab <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Water Jet <input type="checkbox"/><br>Large Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier Quality <input type="checkbox"/> |  |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |                         |  |                           |  |  |  |                                                                                           |  |
| Part No. <u>20UR-09</u>                                                                                                                                                                                                                                                                                                                                                                        |  |                                                                                                                                          |  | Date : <u>19-04-14</u>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |  |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      | Sequence #: <u>Op#1</u> |  | QTY Affected : <u>+ 6</u> |  |  |  | MRB (QSI042)<br><u>Miler</u><br><u>MAY 3/2019</u><br>Completed By<br><u>P.J. 19-04-14</u> |  |
| <b>Description Work Order Deviation</b><br><br><u>engraving tool crashed.</u>                                                                                                                                                                                                                                                                                                                  |  |                                                                                                                                          |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |  |  | <b>Disposition</b><br><br><u>Fixt program</u><br><u>BLEED OUT HEAVY DAMAGE &amp;</u><br><u>ENSURE A SMOOTH TRANSITION</u><br><u>MAX DEPTH 0.020"</u>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                         |  |                           |  |  |  | Lead hand / Supervisor<br><u>OK 19/04/14</u>                                              |  |
| <b>Root Cause</b><br>Operator <input checked="" type="checkbox"/><br>Manufacturing Process <input type="checkbox"/><br>Equip/Tooling <input type="checkbox"/><br>Handling/Preservation <input type="checkbox"/><br>Material <input type="checkbox"/><br>Product Improvement <input type="checkbox"/><br>Process Improvement <input type="checkbox"/><br>Human Factors <input type="checkbox"/> |  |                                                                                                                                          |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |  |  | <b>FAULT CATEGORY</b><br>Pressure/Forced <input type="checkbox"/> Contamination <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Positioned Wrong <input type="checkbox"/><br>Bending <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Folio/Program <input type="checkbox"/> Outside Tolerance <input type="checkbox"/><br>Crushing <input type="checkbox"/> BOM/Route <input type="checkbox"/> Grain Direction <input type="checkbox"/> Drawing <input type="checkbox"/><br>Cracks <input checked="" type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Weld <input type="checkbox"/> Finish <input type="checkbox"/><br>Crimp/Kink/Ripple/Wave/Twist <input type="checkbox"/> Incomplete/Unclear Instructions <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/><br>Marks/Chatter <input type="checkbox"/> Drill Holes <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Misread <input type="checkbox"/><br>Mislabeled <input type="checkbox"/> Fit/Function <input type="checkbox"/> Off-set/Set-up <input type="checkbox"/> |                         |  |                           |  |  |  | QC / QA Coordinator<br><u>DAS</u><br><u>68</u><br><u>9-89</u><br><u>MAY 13 2019</u>       |  |
| Other/Details:                                                                                                                                                                                                                                                                                                                                                                                 |  |                                                                                                                                          |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |  |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |                         |  |                           |  |  |  |                                                                                           |  |